

Date: Monday, 4/24/2006 10:25:15 AM
 User: Kim Johnston

Process Sheet

edit

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PROP ASSEMBLY
 Job Number : 26759
 Estimate Number : 11558
 P.O. Number : *N/A*
 This Issue : 4/24/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : SMALL /MED FAB
 Previous Run : *N/A*
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 06.04.24
 Comment : Est. B02.03.05 Added dwg Rev.A1 NG

Part Number : D3085041
 Drawing Number : D3085 REV A1
 Project Number : N/A
 Drawing Revision : A1
 Material : *N/A*
 Due Date : 5/5/2006 Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D30153 Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Lock Nut

Pick:

Qty	Part Number	Description	Batch
1	D3015-3	Locknut	<i>B27031</i>

327031
B27031
B27031 *NOT IN COMP*

2.0 D30811 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Hinge

Pick:

Qty	Part Number	Description	Batch
1	D3081-1	Prop Hinge	<i>B26796</i>

B26796

3.0 D30821 Clip



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Clip

Pick:

Qty	Part Number	Description	Batch
1	D3082-1	Clip	<i>B16942</i>

B16942 *ymip*

4.0 D30841 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Strut

Pick:

Qty	Part Number	Description	Batch
1	D3084-1	Prop arm	<i>B16943</i>

B26792 *3mip*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/24/2006 10:25:15 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PROP ASSEMBLY

Job Number: 26759

Part Number: D3085041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
1	AN4-5A	Bolt	M100857

6.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
3	AN960JD10	Washer	M100743

7.0

AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
3	AN960JD10L	Washer	M101291

8.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	AN960JD416	Washer	M19185

9.0

AN960JD516L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
1	AN960JD516L	Washer	M17619

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/24/2006 10:25:15 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PROP ASSEMBLY

Job Number: 26759

Part Number: D3085041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
3	MS21042L3	Nut(or MS21042-3)	M101390

11.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
1	MS21042L4	Nut(or MS21042-4)	M19085

12.0

MS27039113

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
3	MS27039-1-13	Screw	M13719

13.0

SL69BS

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Ball Stud

Pick:

Qty	Part Number	Description	Batch
1	SL69-BS	Ball Stud	M100369

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3085

FF 06.09.01 4

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP


Ja-09-05 (4)

13.1 cut 1x D2856-xxx AS per dwg.
Abrasion strip.

B. 25656

(P10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-09-05	13	Add D2856 cut AS per Dwg to w/o. i update Dwg to specify. Perm. Change.					 06-09-05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/09/12
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PROP ASSEMBLY

Job Number: 26759

Part Number: D3085041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST122*

Rec'd 4/18 (4)
AB 06/09/05 (4)

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(4)
06/09/05

Job Completion



Dart Aerospace Ltd

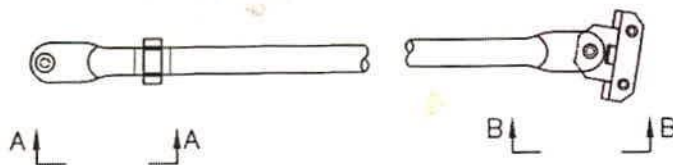
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

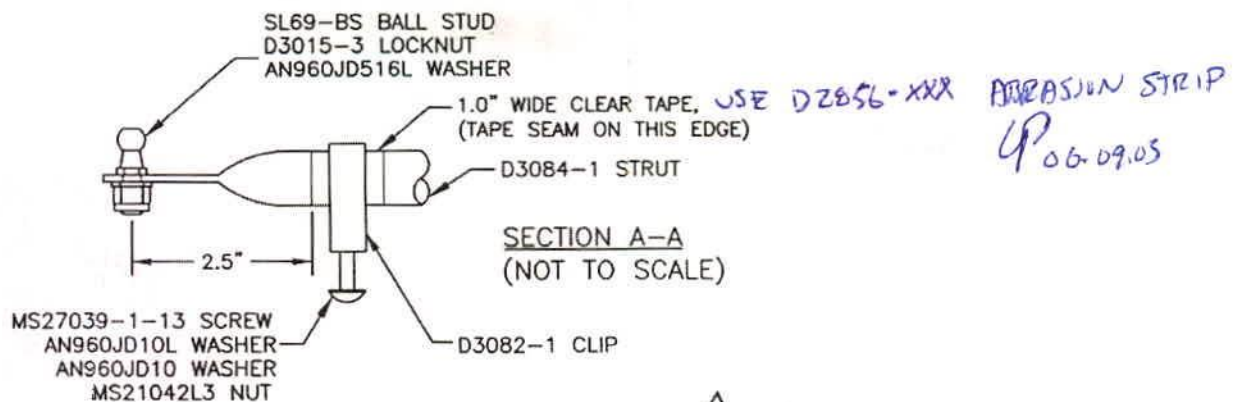
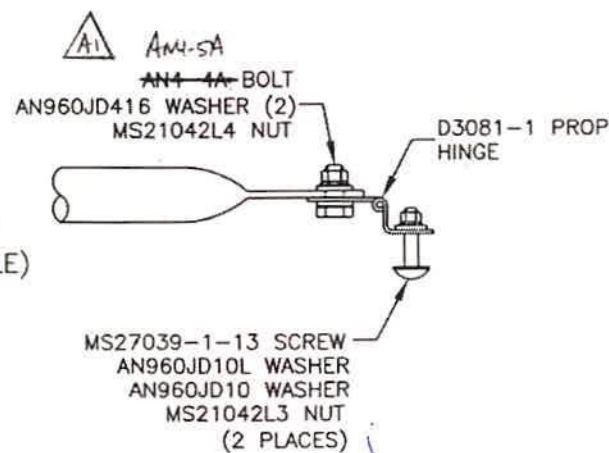
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
02-01-25

D3085-041 PROP ARM ASSEMBLY

SECTION B-B
(NOT TO SCALE)

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
DATE		TITLE	SCALE
02.01.23		PROP ARM ASSEMBLY	1:5
A	02.01.23	NEW ISSUE	
A1	02.02.25	Am4-SA WKS Am4-4A	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26759

Date: Wednesday, 9/6/2006 8:22:12 AM

User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number	: 26759	Customer	: Dart Helicopters Services
Estimate Number	: 11558	DWG Name	: PROP ASSEMBLY
Purchase Order #	:	Part Number	: D3085041
Complete Date	: / / : : AM	DWG Number	: D3085 REV A1
		Rev.	: A1

DUE DATE	ORDERED	DELIVERED
5/5/2006	6	0

1.0 D30153-Lock Nut	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
8/31/2006	FRAN01: Franken, Frans	D30153	6.000	\$0.84	Lot # 27031 Qty. 6
Subtotal:	QTD:	0 CTD:	6	\$0.84	

2.0 D30811-Hinge	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
8/31/2006	FRAN01: Franken, Frans	D30811	6.000	\$552.76	Lot # 26790 Qty. 6
Subtotal:	QTD:	0 CTD:	6	\$552.76	

3.0 D30821-Clip	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
8/31/2006	FRAN01: Franken, Frans	D30821	4.000	\$61.44	Lot # 16942 Qty. 4
Subtotal:	QTD:	0 CTD:	4	\$61.44	

4.0 D30841-Strut	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
8/31/2006	FRAN01: Franken, Frans	D30841	3.300	\$61.93	Lot # 16943 Qty. 0 Lot # 26792 Qty. 3
Subtotal:	QTD:	0 CTD:	3	\$61.93	

5.0 AN45A-Bolt	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
8/31/2006	FRAN01: Franken, Frans	AN45A	6.000	\$0.83	Lot # 100857 Qty. 6
Subtotal:	QTD:	0 CTD:	6	\$0.83	

6.0 AN960JD10-Washer	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
8/31/2006	FRAN01: Franken, Frans	AN960JD10	18.000	\$0.64	Lot # 100743 Qty. 18
Subtotal:	QTD:	0 CTD:	18	\$0.64	

7.0 AN960JD10L-Washer	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
8/31/2006	FRAN01: Franken, Frans	AN960JD10L	18.000	\$0.46	Lot # 101291 Qty. 18
Subtotal:	QTD:	0 CTD:	18	\$0.46	

8.0 AN960JD416-Washer	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
8/31/2006	FRAN01: Franken, Frans	AN960JD416	12.000	\$0.40	Lot # 19185 Qty. 12
Subtotal:	QTD:	0 CTD:	12	\$0.40	

Date: Wednesday, 9/6/2006 8:22:12 AM

User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number	: 26759	Customer	: Dart Helicopters Services
Estimate Number	: 11558	DWG Name	: PROP ASSEMBLY
Purchase Order #	:	Part Number	: D3085041
Complete Date	: / / : : AM	DWG Number	: D3085 REV A1
		Rev.	: A1

9.0 AN960JD516L-Washer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/31/2006	FRAN01: Franken, Frans	AN960JD516L	6.000		\$0.36		Lot # 17619 Qty. 6
Subtotal:		QTD:	0	CTD:	6	\$0.36	

10.0 MS21042L3-Nut INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/31/2006	FRAN01: Franken, Frans	MS21042L3	18.000		\$1.84		Lot # 101390 Qty. 18
Subtotal:		QTD:	0	CTD:	18	\$1.84	

11.0 MS21042L4-Nut INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/31/2006	FRAN01: Franken, Frans	MS21042L4	6.000		\$0.37		Lot # 19085 Qty. 6
Subtotal:		QTD:	0	CTD:	6	\$0.37	

12.0 MS27039113-Screw INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/31/2006	FRAN01: Franken, Frans	MS27039113	18.000		\$2.01		Lot # 13719 Qty. 18
Subtotal:		QTD:	0	CTD:	18	\$2.01	

13.0 SL69BS-Ball Stud INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
8/31/2006	FRAN01: Franken, Frans	SL69BS	6.000		\$4.44		Lot # 100369 Qty. 6
Subtotal:		QTD:	0	CTD:	6	\$4.44	

14.0 SMALL FAB 1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
5/30/2006	DROU02: Drouin, Steven	Run	0.000	0.50	\$6.40	0.50	14.66
8/31/2006	FRAN01: Franken, Frans	Run	6.000	0.03	\$0.41	0.03	1.20
8/31/2006	FRAN01: Franken, Frans	Run	6.000	1.98	\$27.36	1.98	79.20
9/1/2006	FRAN01: Franken, Frans	Run	4.000	1.44	\$19.90	1.44	57.60
Subtotal:		QTD:	16	CTD:	0	3.95	\$206.73

16.0 PACKAGING 1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
8/31/2006	DESJ02: Desjardins, Line	Run	0.000	0.50	\$6.89	0.50	10.00
9/5/2006	BROS01: Brosseau, Lynn	Run	4.000	0.22	\$2.86	0.22	4.40
Subtotal:		QTD:	4	CTD:	0	0.72	\$24.15

		TIME	COST
	Machine Time:	4.67	\$167.06
	Labor:	4.67	\$63.82
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$688.32
	SUB-COMPONENT (SUB-JOB):		\$0.00
Total:			\$919.20
COST PER UNIT:			\$919.20